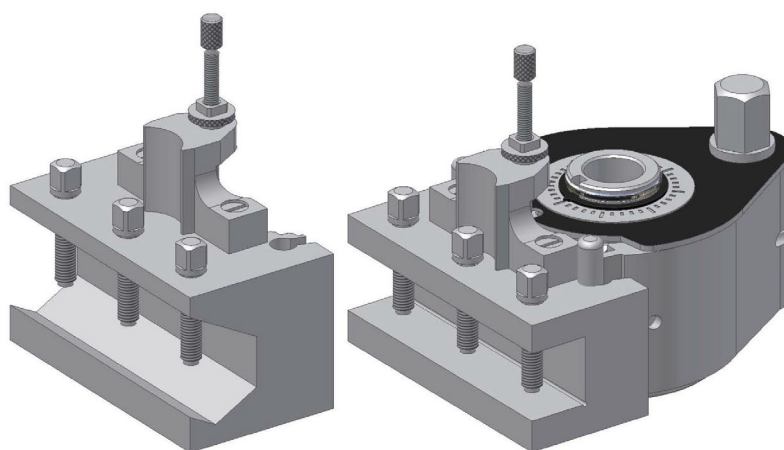


Data sheet ***Mounting instruction***

Quick action tool holder

SWH 3 - E

3384303



1 Quick-change tool holder - SWH 3- E

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1 Quick-change tool holder - SWH 3- E

1.1 Introduction

Quick-change tool holders are characterised by great diversity in tool use. The base body, made of high-quality heat-treated steel with profile-ground holding teeth, is fastened to the top slide. The tool holders engage with the teeth of the base body, achieving a repeatability of 0.01 mm. The serration allows 40 different tension settings of the tool holder.

1.2 Intended use

The quick-change tool holder SWH 3-E can be used on the following machines:

OPTIMUM - Lathe

- TU3209V, TU3610V, TH3309 / TH3309D / TH3309V, TH3610 / TH3610D, TH4010 / TH4010D / TH4010V

Use on other lathes is possible, but the maximum permissible spindle drive power of the respective lathe must not be exceeded.

WARNING!

First commissioning may only take place after proper installation.



1.3 Technical specification

Turning diameter [mm]	200 - 400
Max. motor power of the lathe [kW]	4.5

1.4 Accessories

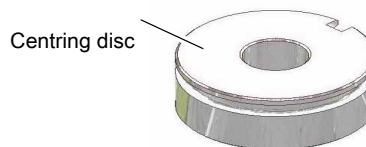
Spare tool holder	Item no.
Spare tool holder 20 x 100 Type D for square	3384304
Spare tool holder 30 x 100 type H for round chisel	3384322

1.5 Mounting the SWH 3- E on the lathe

Components must be turned out and drilled

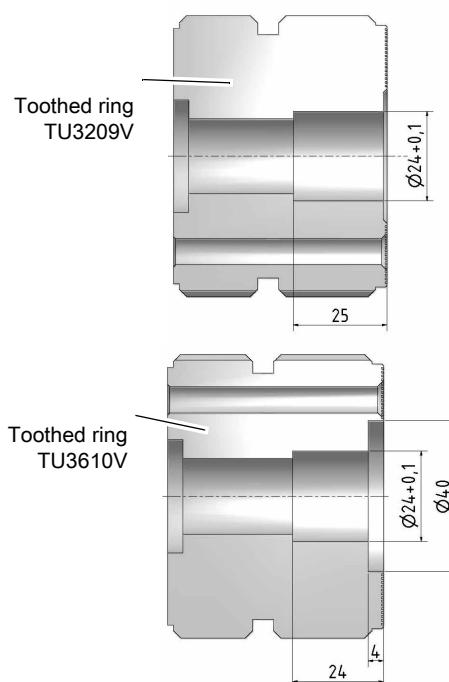
Proceed as follows.

- Turn out the bore of the centring disc to $\varnothing 16$ mm.



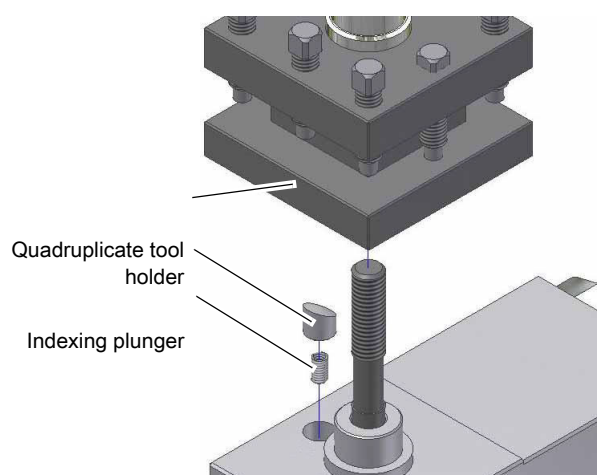
Img. 1-1: Centring disc

- Bore out the holes in the toothed ring as shown in the drawing opposite.



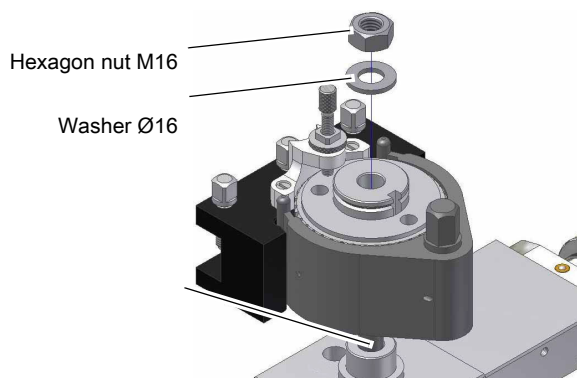
Img. 1-2: Toothed ring

- Dismantle the quadruple tool holder, the locking bolt and the Spring.



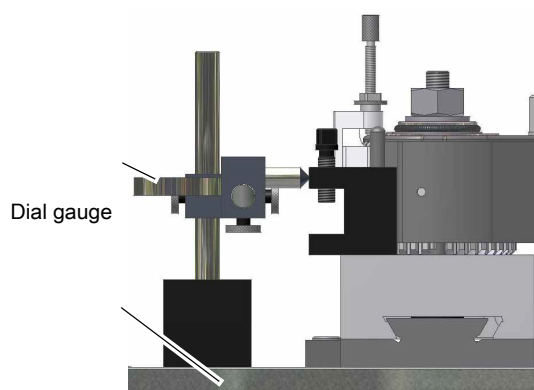
Img. 1-3: Quadruple tool holder, dismantling

- Place the quick-change tool holder without indicator scale on the locating bolt.
- To do this, place the quick-change tool holder offset by 90°. Alignment parallel to the spindle axis facilitates the subsequent measuring process.
- Then tighten the hexagon nut lightly with an open-end spanner.



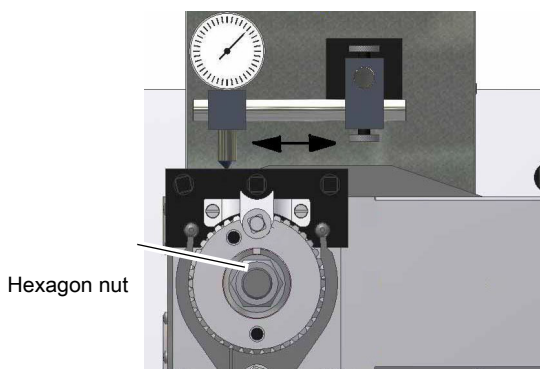
Img. 1-4: Quick-change tool holder, assembly

- Place a dial gauge with magnetic stand on the cross slide. Measure the squareness of the tool holder by moving the top slide.



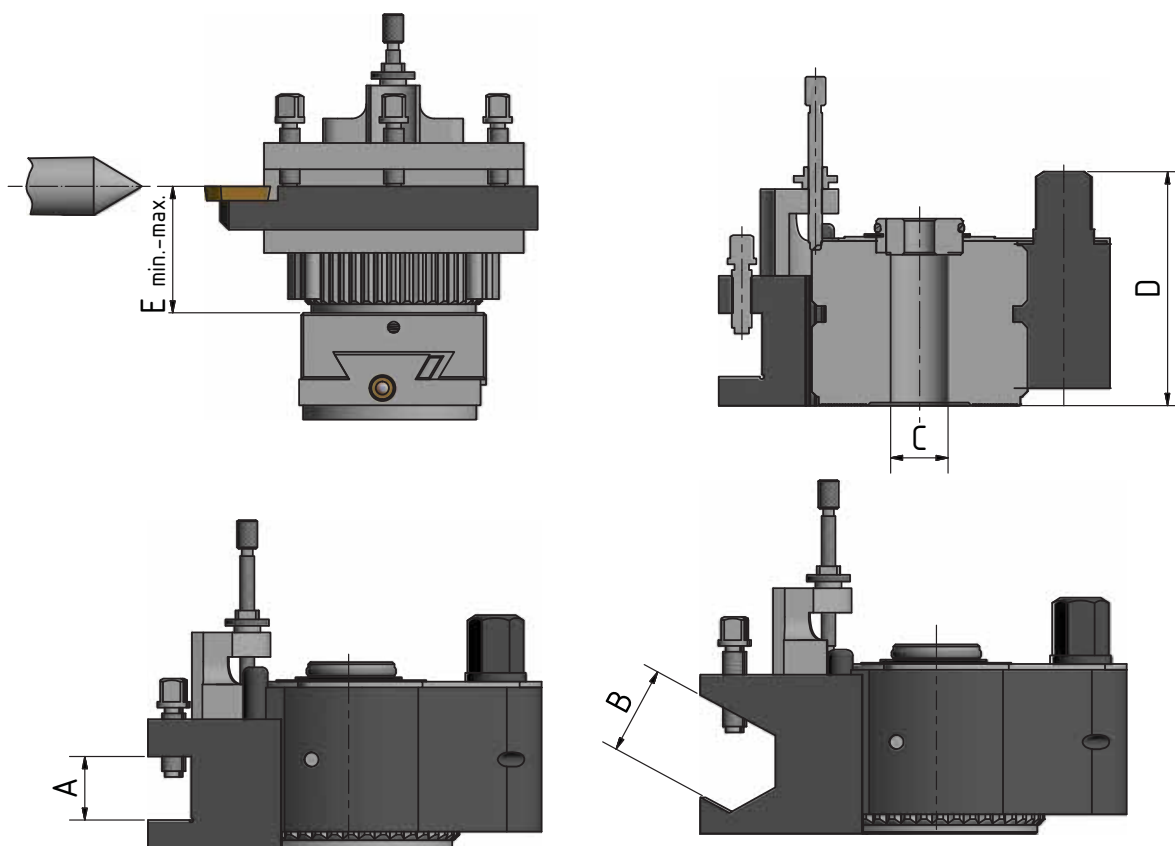
Img. 1-5: Check perpendicularity

- If necessary, adjust the squareness by moving the tool holder with the measuring tool.
 - Then tighten the hexagon nut on the aligned quick-change tool holder.
- When doing so, make sure that the quick-release holder does not twist again.



Img. 1-6: Set perpendicularity

2 SWH 3-E - Abmessungen - *Dimensions*



Abmessungen - *Dimensions*

Auflagenbreite Vierkantmeißel max. <i>Support width of square tool</i>	A	20 mm
Durchmesser Rundmeißel max. <i>Diameter round tool max.</i>	B	30 mm
Bohrung normal <i>Hole standard</i>	C	20 mm
Höhe Grundkörper/Gesamt <i>Height of base body/Total</i>	D	68 mm
Höhe Oberschlitten bis Drehmitte <i>Height of top slide to the center of rotation</i>	E	28,5 - 39,5 mm 28.5 - 39.5 mm

3 Ersatzteile - Spare parts

3.1 Ersatzteilbestellung - Ordering spare parts

Bitte geben Sie folgendes an - *Please indicate the following :*

- Maschinenbezeichnung - *Machines name*
- Herstellungsdatum - *Date of manufacture*
- Artikelnummer - *Article no.*

Die Artikelnummer befindet sich in der Ersatzteilliste. *The article no. is located in the spare parts list.*

3.2 Hotline Ersatzteile - Spare parts Hotline



+49 (0) 951-96555 -118

ersatzteile@stuermer-maschinen.de



3.3 Service Hotline



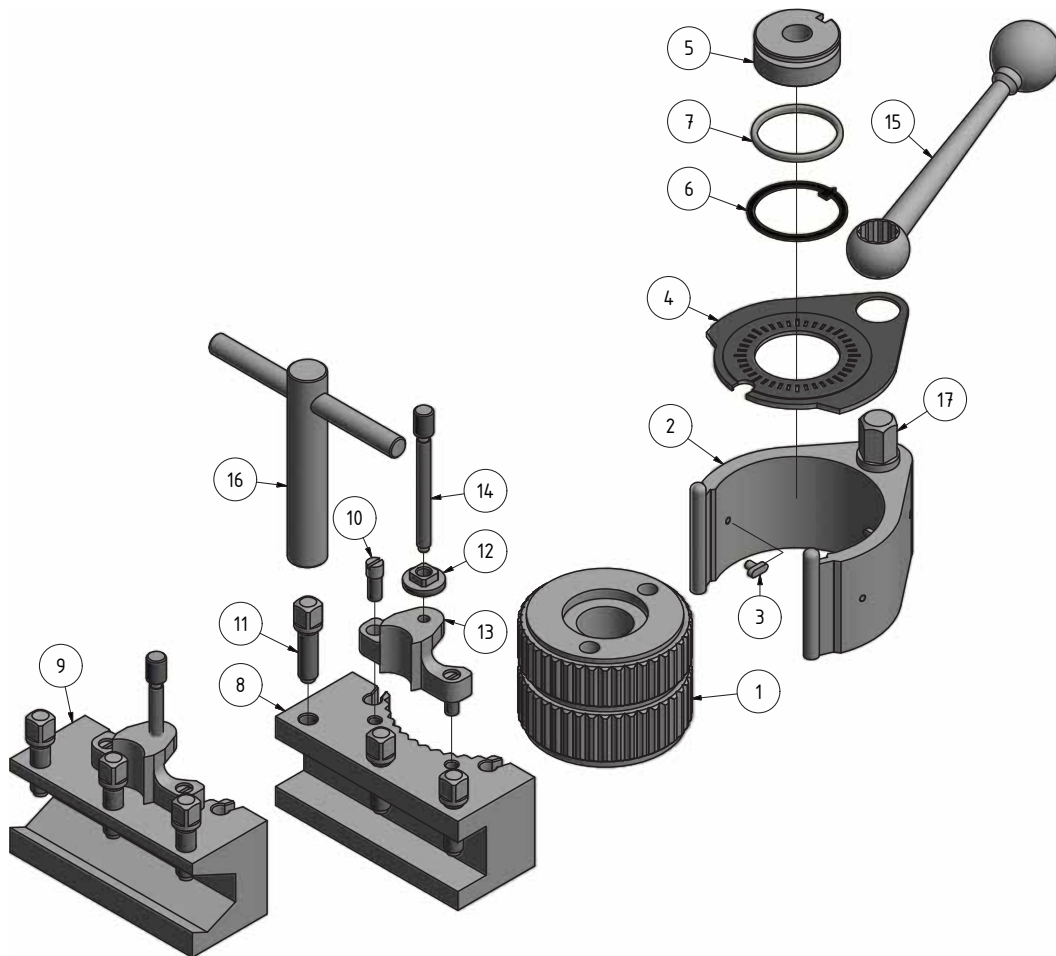
+49 (0) 951-96555 -100

service@stuermer-maschinen.de



3.4 Ersatzteilzeichnungen - Spare part drawings

SWH 3-E



SWH 3-E					
Pos.	Bezeichnung	Designation	Menge Qty.	Größe Size	Artikelnummer Item no.
1	Zahnkranz	Crown gear	1		0338430301
2	Schnellwechsellaufnahme	Quick-action collet	1		0338430302
3	Nutenstein	Slot nut	3		0338430303
4	Anzeige-Skala	Indicator scale	1		0338430304
5	Zentrierscheibe	Centering washer	1		0338430305
6	Führungsstück	Guide piece	1		0338430306
7	Feder	Spring	1		0338430307
8	Werkzeughalter Vierkantmeißel Typ D	Holder square tool, Typ D	1		3384304
9	Werkzeughalter Rundmeißel Typ H	Holder round tool, Typ H	1		3384322
10	Zylinderschraube	Head cap screw	4	32G-5/32	0338430310
11	Klemmschraube	Locking screw	6	M7x30	0338430311
12	Kontermutter	Counter nut	2	32G-5/32	0338430312
13	Oberteil-Höhenverstellung	Top adjustment of height	2		0338430313
14	Höhenverstellungsschraube	Screw adjustment of height	2	32G-5/32	0338430314
15	Ringschlüssel	Ring spanner	1		0338430315
16	Vierkantschlüssel	Square socket key	1		0338430316
17	Exzenter	Eccentric	1		0338430317

